

Date: Monday, 12/29/2008 9:52:52 AM  
 User: Marc Bellavance

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 44341  
 Estimate Number : 11038  
 P.O. Number :  
 This Issue : 12/29/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : MACHINED PARTS  
 Previous Run : 44264  
 Written By :  
 Checked & Approved By : 08.12.29  
 Comment : Est D 05.03.30 MS21043-3 was MS21042L3 KJ/JLM

Drawing Name : BRACKET ASSEMBLY - OBSOLETE  
 Part Number : D2804044  
 Drawing Number : D2804 REV 0 C  
 Project Number : N/A  
 Drawing Revision : ~~OBSOLETE~~ 08.12.29  
 Material :  
 Due Date : 1/5/2009 Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D28042 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STA 155 Bracket

Pick:

Qty	Part Number	Description	Batch
1	D2804-2	Bracket	B41740

08/12/29

2.0 D28054 Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Stop

Pick:

Qty	Part Number	Description	Batch
1	D2805-4	Stop	B28183

08/12/29

3.0 D2809 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	B39727

08/12/29

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Press D2805-4 into arm as per Dwg D2804

08/12/29 ①

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Job Number: 44341

Part Number: D2804044

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08.12.29*

6.0

POWDER COATING

POWDER COATING



*M109996*



*(1X)*

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*10:45*  
*320 OF*  
*11:15*

*M-1 08/12/29*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08/12/29*

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2804

*08/12/29*

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C16A

Bolt

*M109147*

*08/12/29*

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

2

MS21043-3 Nut

*M109535*

*08/12/29*

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Drawing Name: BRACKET ASSEMBLY - OBSOLETE

Job Number: 44341

Part Number: D2804044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	NAS1515H3	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Pick:

Qty Part Number Description

Batch

4 NAS1515H3

Washer

M107101

A/R LPS-3

Corrosion Spray

M109929

CP08/12/25

12.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

CP08/12/29

13.0	QC5	INSPECT WORK TO CURRENT STEP
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08.12.29 ①



Comment: INSPECT WORK TO CURRENT STEP

14.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57148

SS 08/12/30 ①

15.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/01/05 ①

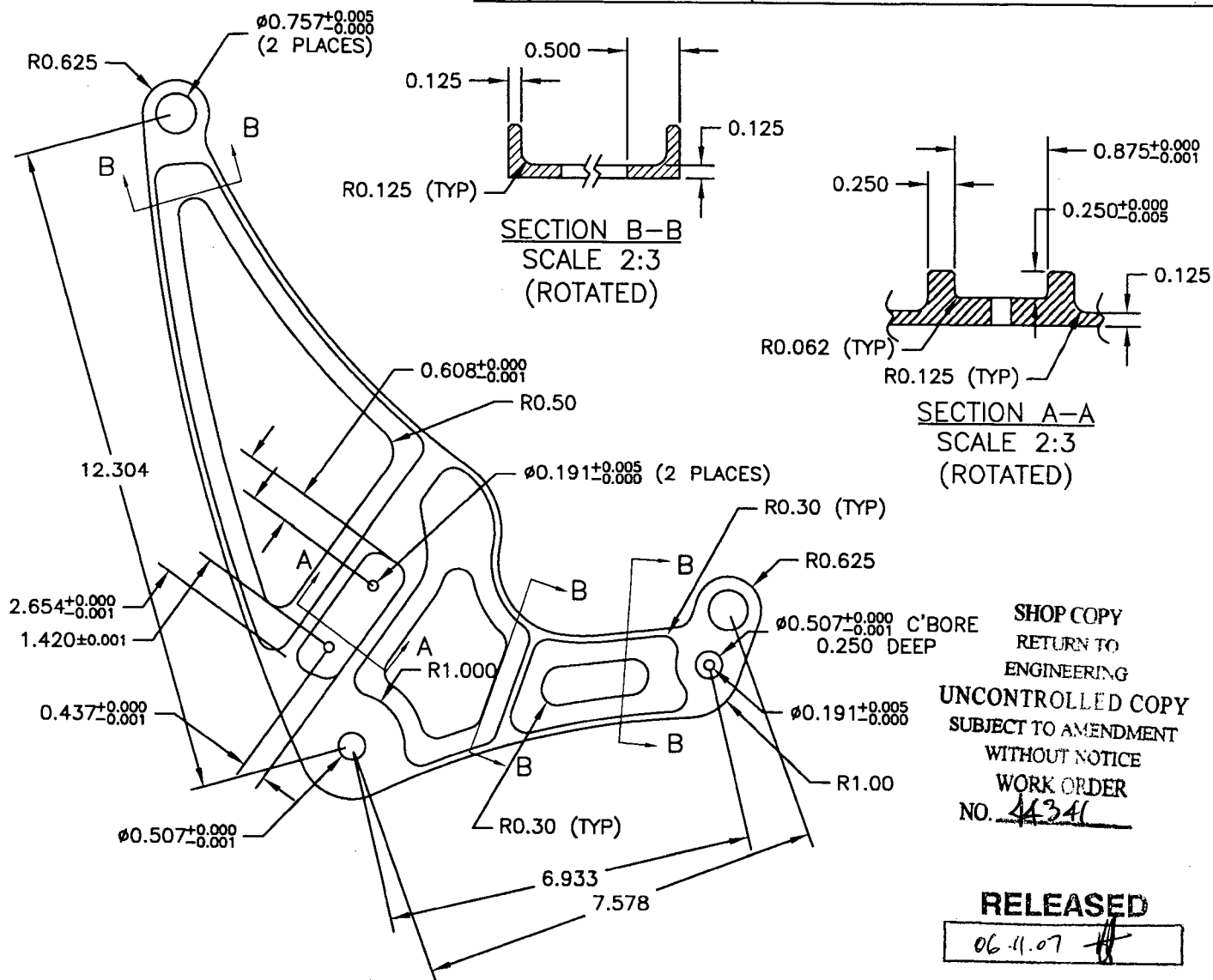
Job Completion



MF 08-12-31

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. C
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	SHEET 1 OF 2
				D2804	
DATE	06.10.16			TITLE	SCALE
				STA 155 BRACKET	1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	
C	06.10.16			CHANGE GEOM. TO ADD CLEARANCE	



**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

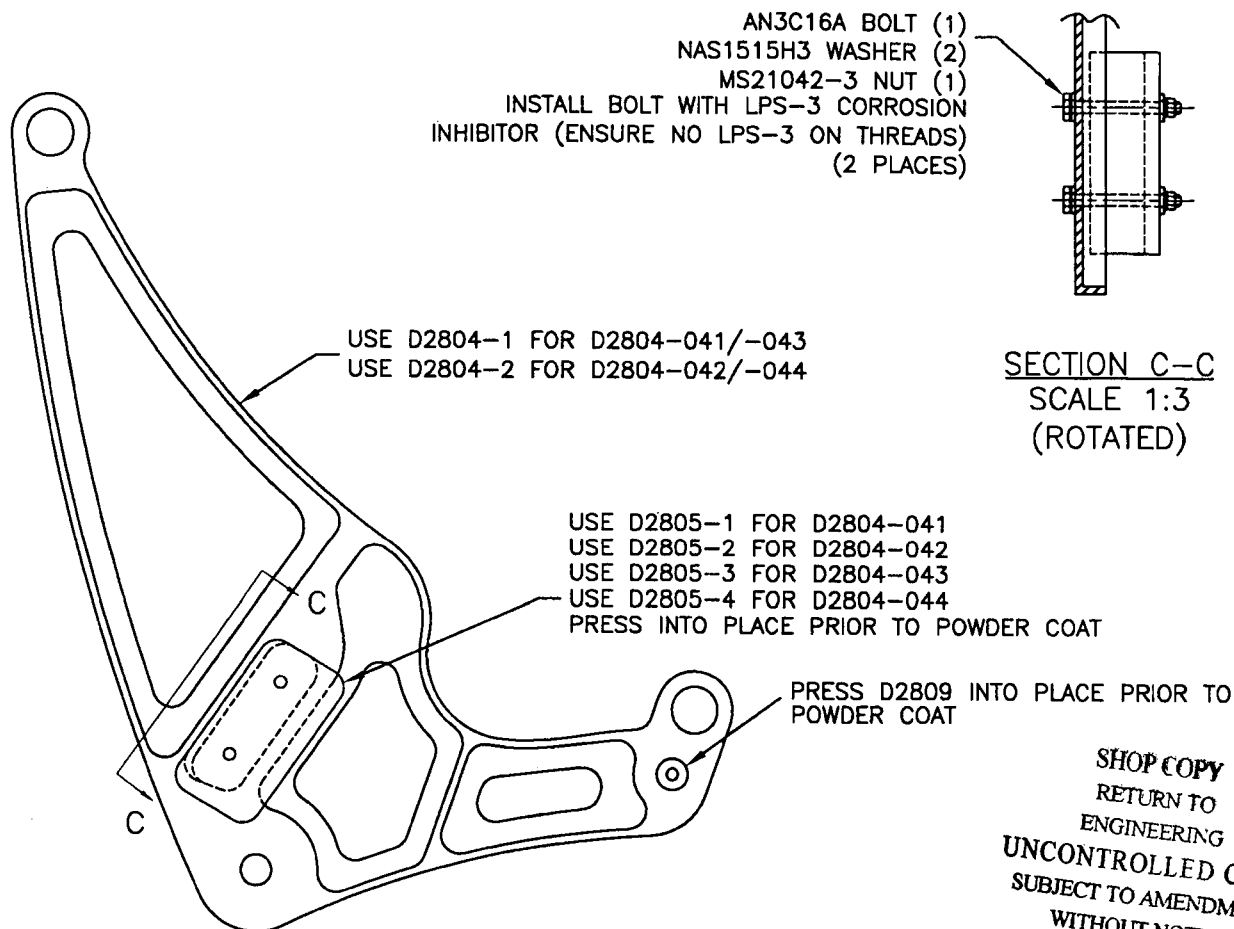
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPR1"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



SECTION C-C  
SCALE 1:3  
(ROTATED)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44341  
RELEASED  
06.11.07 

**D2804-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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